

Date: Wednesday, 10/10/2007 11:04:41 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HOUSING
Job Number	: 35094		
Estimate Number	: 11870		
P.O. Number	: <u>N/A</u>	Part Number	: D22071
This Issue	: 10/10/2007 S.O. No. : <u>N/A</u>	Drawing Number	: D2207 REV C
Prsht Rev.	: <u>NC</u>	Project Number	: N/A
First Issue	: <u>N/A</u> Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: 34326	Material	: <u>N/A</u>
Written By	: <u>[Signature]</u>	Due Date	: 10/31/2007
Checked & Approved By	: <u>[Signature]</u>	Qty:	<u>15</u> Um: Each
Comment	: Est. A 01.03.08 New Issue Est rev B 07.09.11 ecn 998 EC verified by: JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S063	6061-T6 .063 Sheet
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Comment: Qty.: 0.4375 sf(s)/Unit Total : 4.3754 sf(s)
 6061-T6 .063 Sheet
 5052-H32 or 6061-T6 - .063" Thick
 Batch M105225 IB 07-10-18

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2207
 Dwg Rev: C
 Prog Rev: C
IB 07-10-18
 2-Deburr if necessary IB 07-10-18

(20)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

IB 07-10-18 (X20) center

5.0	BENDING	BENDING MACHINE
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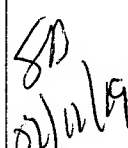


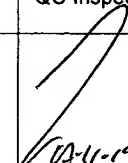
Comment: BENDING MACHINE
 Bend as per dwg D2207

IB 07-11-19 (19) PTO

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 2 Date: 07/11/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/11/19	5	1 piece was out of tolerance 1st piece at the set-up	 05/10/19	Scrap & destroy	 07/11/19	 07.11.19	 05/10/19	 05.11.19

NOTE: Date & initial all entries

Date: Wednesday, 10/10/2007 11:04:41 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HOUSING

Job Number: 35094

Part Number: D22071

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/11/19 (19)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS

PD 07-11-20 (19)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/20 (19)

Job Completion



U 07-11-20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	35094
Description: Housing		Part Number:	D2207-1
Inspection Dwg: D2207	Rev: <i>REV.C</i>		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST


x

First Article

Prototype

[illegible]

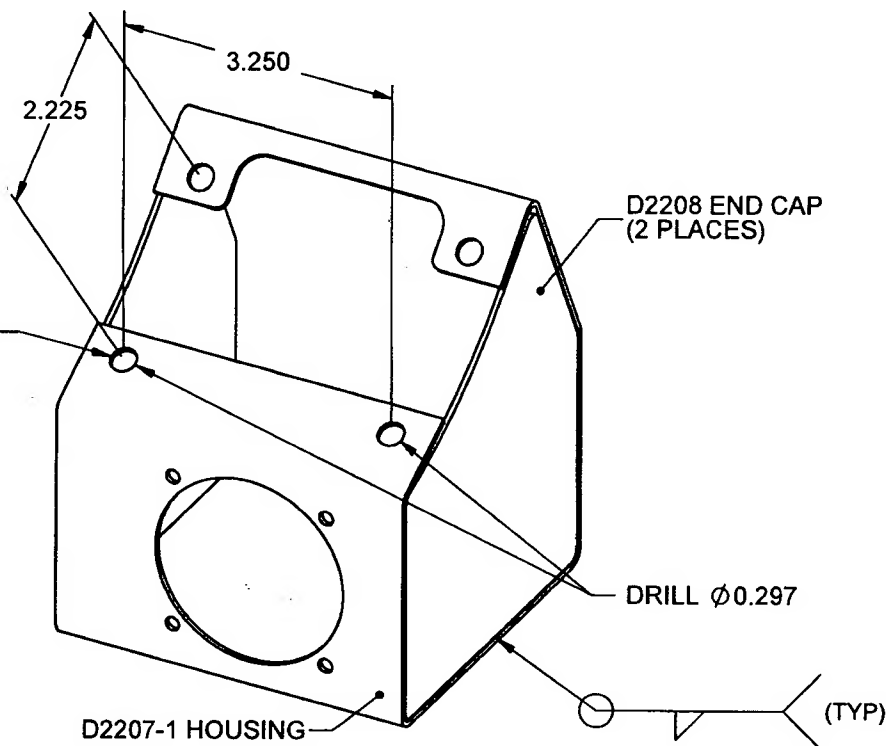
Measured by:	HB
Date:	07-10-19

Audited by:	
Date:	24/11/19

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.11.11	New Issue P/O D206-539-013	KJ/JLM	

AFTER FINISH, INSTALL
AKS7-1032-130 OR
ALS7-1032-130 OR
AKS4-1032-130 OR
ALS4-1032-130
(4 PLACES)



RELEASED

07.08.29

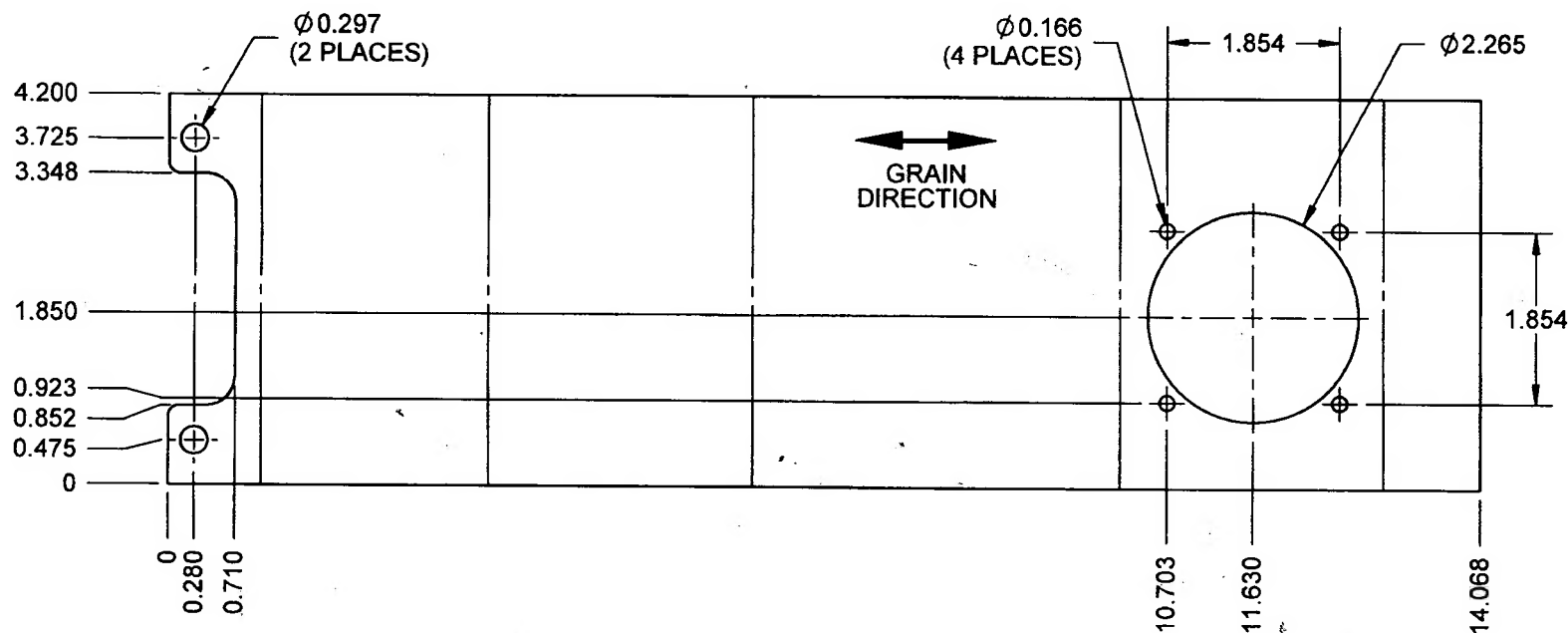
D2207-041 HOUSING ASSEMBLY

NO. 35094
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

NOTES:

- 1) WELD PER DART QSI 004
- 2) GRIND WELDS FLUSH
- 3) FINISH: ACID ETCH AND ALODINE PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

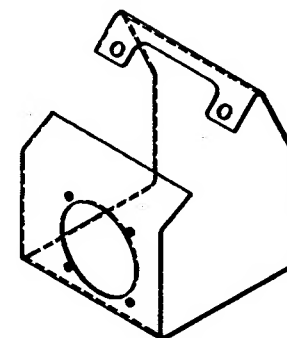
C	- UPDATE FLAT PATTERN - TOOLING REWORK REQUIRED	MB	07.06.28
B	REDRAWN	RF	01.02.23
A	NEW ISSUE	RF	94.09.01
REV.	DESCRIPTION	BY	DATE
DESIGN	TH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D2207	SHEET 1 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	HOUSING	1:2
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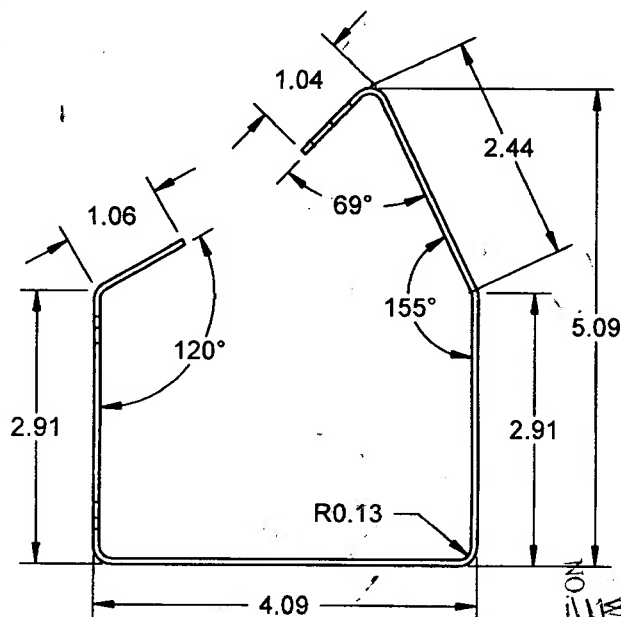
D2207-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 5052-32 ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/8 OR AMS 4016
(REF. DART SPEC. M5052H32S.063) OR
6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



ISOMETRIC VIEW
(SCALE 1 : 4)



D2207-1 BENDING DETAIL

RELEASED

07.08.29

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 35094

DESIGN	<i>PH</i>	DART AEROSPACE LTD	
DRAWN	<i>PH</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>PH</i>	D2207	SHEET 2 OF 2
APPROVED	<i>PH</i>	TITLE	SCALE
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